

Work Order ID 84792

84792

Page 1

May-23-12 10:05:28 AM

Item ID: D3827-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly (Inboard)

Start Date: 23/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 30/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3827	Rev A

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c/sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: M121602

7- grind weld-flush

8- deburr if necessary

CC 12-6-13

SAN 12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

130

QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: WA

0.00

150

Packaging

Memo

0.00

Packaging

6 CPL12.06.14

6 CPL12.06.14

6 CPL12.06.14

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Page 3

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC21- Final Inspection - Work Order Release	0.00							
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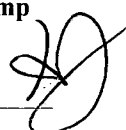
160

QC

Memo

Quality Control

0.00

12/6/18 

ME
12-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-23-12 10:05:32 AM

Page 1

Work Order ID: 84792

84792

Parent Item: D3827-041

D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 23/05/2012

Required Date: 30/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	352.0000	3	18			

D3759-1

Bushing

**

CC 12-6-13

Location	Loc Qty	Loc Code
WA	202	
79213	1	
83464	201	
WA005	150	
66489	1	
82785	149	

M304TS0.750W.065

Purchased

No

100

f

511.2565

8

50.52632

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

SAD

12-05-03

Location	Loc Qty	Loc Code
MAT017	384.1237042	
120267	53.7325342	
120633	330.39117	
MAT018	120.47539	
121170	79.47539	
7636	41	
WA007	0.5907428	
116763	0.5907428	
WA035	6.0667	
118181	6.0667	

50.5264

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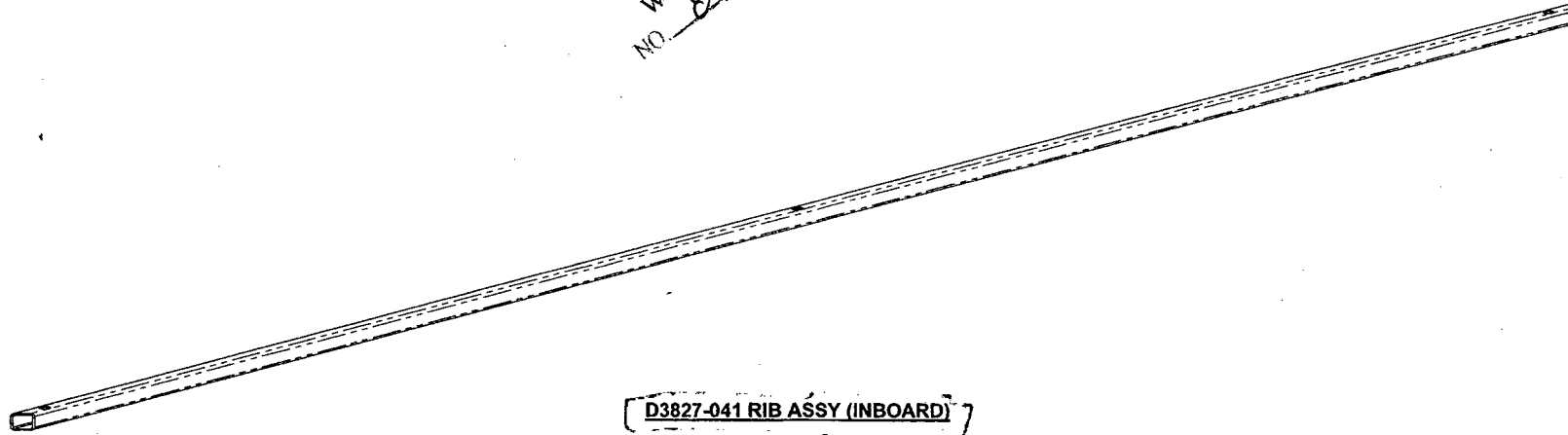
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84792 MLJ
12/05/23



D3827-041 RIB ASSY (INBOARD)

RELEASED
08/11/23 MLJ

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3827** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (INBOARD)** SCALE NTS

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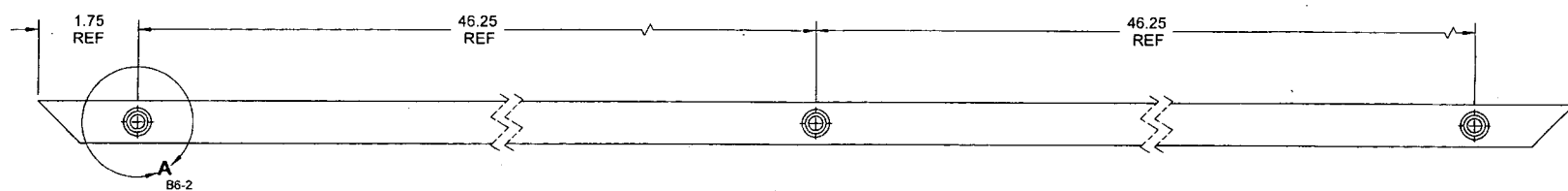
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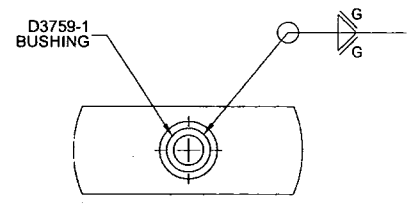
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NOTE: Date & initial all entries

24792



D3827-041 RIB ASSY (INBOARD)



DETAIL A C7-2
SCALE 2X
3 PL

RELEASED
08/11/81

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3827	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		RIB ASSY (INBOARD)	SCALE
DE APPR.			NTS
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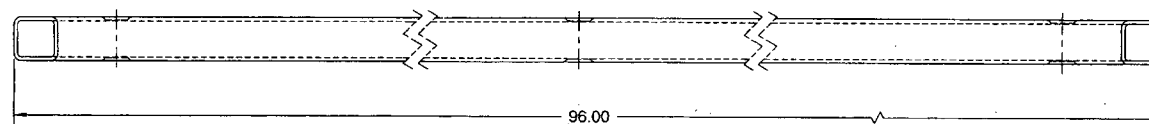
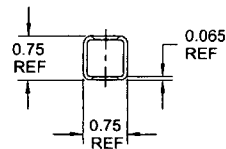
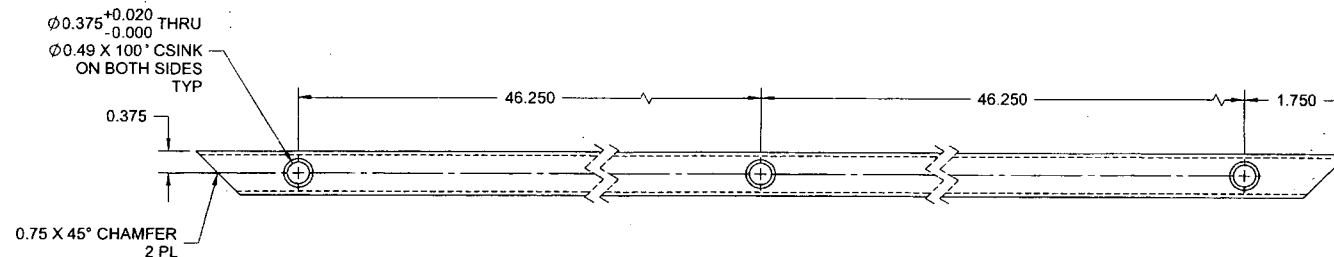
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24792



D3827-1 RIB

RELEASED
08/11/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3827	REV. A
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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